

Date:
User:Tuesday, 4/18/2006 10:03:53 AM
Kim Johnston

Process Sheet

21

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 26675
Estimate Number : 10559
P.O. Number : N/A
This Issue : 4/18/2006 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : LANDING GEAR
Previous Run : 26674
Written By : See Comment Below
Checked & Approved By : 06.04.18
Comment : Est Rev: E 04.02.16 Reformat; Added D3189-1 K/DS
 Est Rev: F 06-03-29 Remove Coments on Pick List JLM

Drawing Name : HIGH AFT X-TUBE 412
Part Number : D412664203
Drawing Number : D412-664-243 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 5/26/2006 **Qty:** 1 **Um:** Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 003

MS 06/05/09

2.0	D6009129	Crosstube Material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129 Crosstube B25942

Check OD = 3.500"; ID = 2.250"

MS 06/05/09 1

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166

MS 06/05/09 1

2-Turn first side as per Folio FA166

MS 06/05/09 1

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243. MS 06/05/09 1

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/05/10 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:03:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26675

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

MS 06/05/10 1

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

MS 06/05/10 1

3-Polish entire outside surface of crosstube

MS 06/05/10 1

4- Remove sand and plugs

MS 06/05/10 1

5-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243

MS 06/05/10 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/05/10 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06-05-10 1

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 06-05-10

9.0

QC3/5

INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

DP 06-5-10

10.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

DP 06-5-11

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

MS 06-05-11
(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:03:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 266751

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 *pm 06-05-12 (1)*

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check *pm 06-05-13 (1)*
dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243 *pm 06-05-15 (1)*

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *pm 06-05-15 (1)*

14.0

OUTSIDE SERVICE.

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038 Or

Issue P/O: *1260* LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order *C206105/16 (1)*

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order. *Ref 1/15 (1)*

16.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203 *06-05-23 (1)*

17.0

SPRAY PAINTING

SPRAY PAINTING

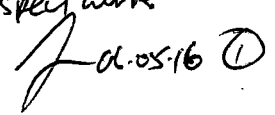
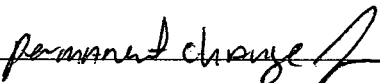
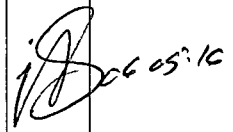
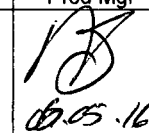
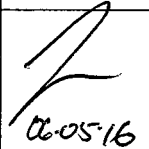


Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2 *FC 06 05 24 (1)*

2-Paint outside crosstube with White Imron as per QSI 005 4.2 *ml 06 05 25 (1)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-16	13-1	Add Qc 5 to inspect work work inspected. <i>for 06-05-16</i>  <i>permanent change</i> 		06-05-16	1	 06-05-16	 06-05-16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:03:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26675

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

06-05-25 ①

19.0

D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total: 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip

B24328 DP06-5-29

20.0

D2856600

Abrasion Strip



Comment: Qty.: 1.0080 f(s)/Unit Total: 1.0080 f(s)

Pick:

Qty Part number Description Batch

1 D2856-600(Cut to 10.870") Abrasion Strip

B24328 DP06-5-29

21.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1 Support

B21240 DP06-5-29

22.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1 Chafing Shield

B25658 DP06-5-29

23.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp

H100479 DP06-5-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:03:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26675

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS2192030

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 MS21920-30

Clamp

M190154

DP06-5-29

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

DP06-5-29

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RE 06-05-29

(1)

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M19099

✓

29.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch:

M19633

✓

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch:

M100191

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 26/05/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26675

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M19099 ✓

Cu 4/18/29 ①

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 206105/29 ①

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

Location: F65

PPP Rev: 0

Cu 4/18/29 ①

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 206105/29

Job Completion



u 0610529

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 26675
Description: Crosstube Assembly (412 High Aft)	Part Number: D412-664-243
Inspection Dwg: D412-664-243 Rev: B	Page 1 of 1

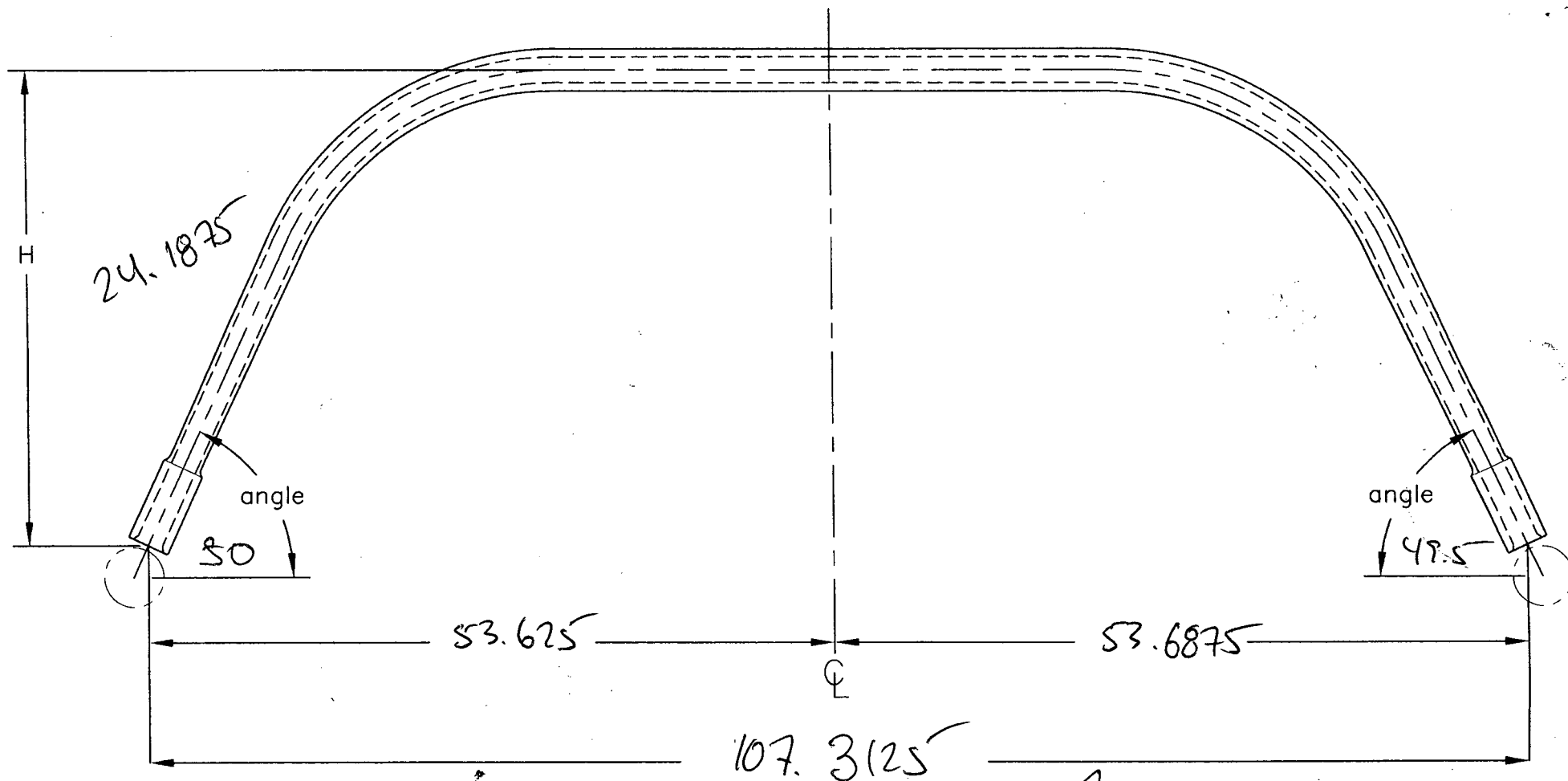
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.688	✓			
	2.748	+0.005/-0.000	2.752	✓			
	2.884	+0.005/-0.000	2.888	✓			
	3.019	+0.005/-0.000	3.023	✓			
	3.163	+0.005/-0.000	3.168	✓			
	3.308	+0.005/-0.000	3.313				
	3.429	+0.005/-0.000	3.433				
	2.990	+0.005/-0.000	2.994	✓			
	2.618	+0.005/-0.000	2.621	✓			
	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.971	+/-0.001	4.971	✓			
SIDE B	2.684	+0.005/-0.000	2.688	✓			
	2.748	+0.005/-0.000	2.752	✓			
	2.884	+0.005/-0.000	2.888	✓			
	3.019	+0.005/-0.000	3.023	✓			
	3.163	+0.005/-0.000	3.168	✓			
	3.308	+0.005/-0.000	3.313	✓			
	3.429	+0.005/-0.000	3.433	✓			
	2.990	+0.005/-0.000	2.995				
	2.618	+0.005/-0.000	2.620	✓			
	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.971	+/-0.001	4.971	✓			
	124.09	+/-0.020	124.10	✓			

Measured by: MS	Audited by: [Signature]	Prototype Approval: N/A
Date: 06/05/09	Date: 06.05.10	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM [Signature]	[Signature]



DATE: 06-05-11

DESCRIPTION: 42-664-203

BATCH NO: 26675

DRAWING: 412-664-243

H: 24.37 } $\pm .06$

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50

[Signature]
06-05-11



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D412-664-243	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) NTS	
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.06.09 [Signature]

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
1	D2856-600-1087	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP
2	D3189-1	CHAFING SHIELD

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 AND D2856-600-1087 ABRASION STRIPS WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2896-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTINAL TO TO SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

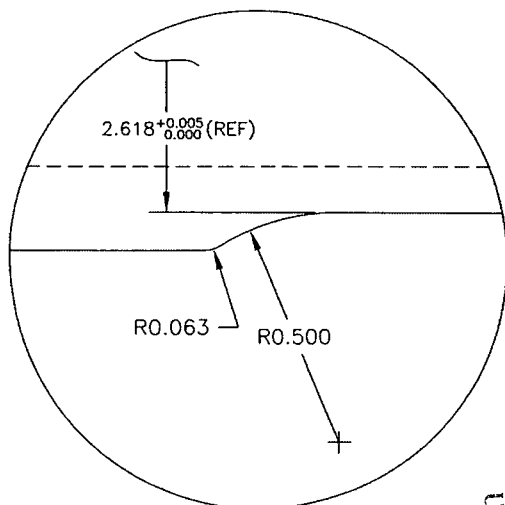
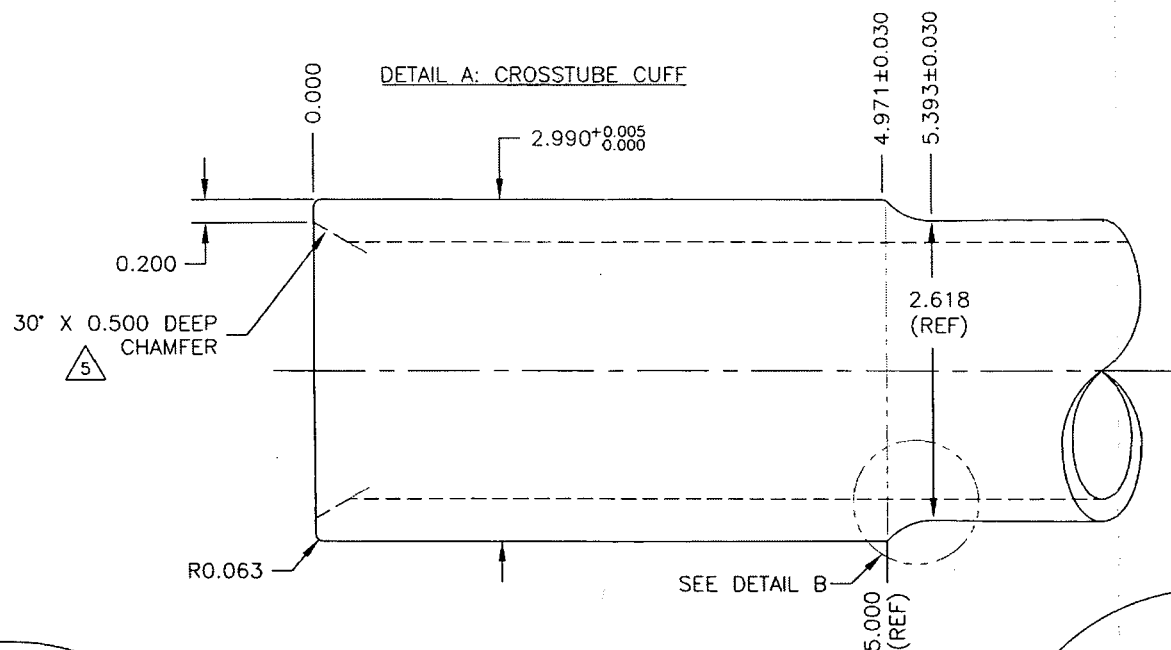
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26675

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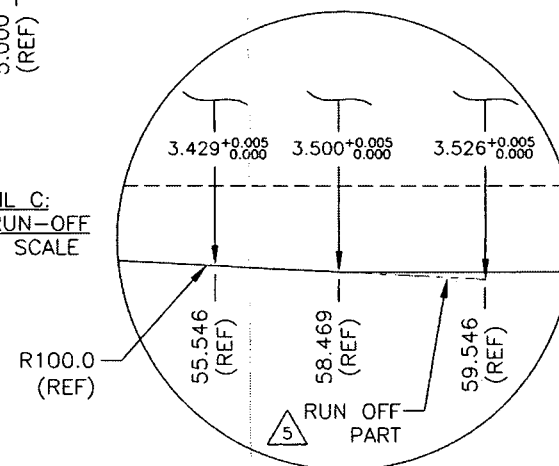


RELEASED
05.06.09



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. WARRICKSLEY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D412-664-243	REV. B SHEET 3 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:1

NO
WORK ORDER
26675
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
RETURN TO
ENGINEERING
SHOP COPY



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lapine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 34150

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (5) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1)	P/N D212-664-101	S/N B26238
Qty (1)	P/N D058-676-201	S/N B19626
Qty (2)	P/N D412-664-203	S/N's B26675 & B25652
Qty (1)	P/N D206-667-203	S/N B25608

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (5) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)

Ardrox 970P25E Batch #04B503.

(5) cross tubes PASSED inspection.

~~THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS~~

INSPECTED BY: 

DATE May 17, 2006

INSPECTION
STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER Dart Aerospace

P.O. NUMBER 00001260

ADDRESS:

CONTACT NAME:

LABOUR	@	\$
MATERIALS	@	
TRAVEL EXPENSES	@	GST
HOTEL EXPENSES	@	PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél: (514) 636-1000 • Fax: (514) 636-0031

W.O. No **34150**

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (5) cross tube (external surface) as per ASTM E-1417-05 and the Dart OSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D212-664-101 S/N B26238
Qty (1) P/N D058-676-201 S/N B19626
Qty (2) P/N D412-664-203 S/N's B26675 & B25652
Qty (1) P/N D206-667-203 S/N B25608



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (5) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)

Ardrox 970P25E Batch #04B503.

(5) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

S. FLETCHER

DATE: May 17, 2006

INSPECTION
STAMP(S)

Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER: 00001260

ADDRESS:

CONTACT NAME:

LABOUR	@	\$
MATERIALS	@	
TRAVEL EXPENSES	@	GST
HOTEL EXPENSES	@	PST

INVOICE NO.

TOTAL \$

WHITE COPY-INSPECTION FILE • YELLOW COPY-CUSTOMER • PINK COPY-ACCOUNTANT



ALUnna

Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1 - EN 10204:2004

Kunde:
Client:

Dart Aerospace Ltd.

1270 Aberdeen Street
K6A1K7 Hawkesbury, ON Canada**Zeugnisnummer:**

364/06

Cert No.: / No. du certificat:

PO 00000670

Bestellnummer:

Order No. / No. de commande

Auftrag:

17896/1

Our Reference/Notre Reference:

Produkt:

Product / Produit:

Spezifikation:

Specification:

Werkstoff:

Alloy/Alliage:

Abmessung

Size / Dimension

Kennzeichnung

Marking/Marquage:

7075

Zustand:

Temper/État

T 6511

3,500 INCH x 2,250 INCH x 0,625 INCH x 129,000 INCH

D6009-129 3.500 X 0.625 X 129

ALUnna-Cert No.364/06-7075-T6511-Cast No.80117-QQA-200/11E-3.500" OD X 0.625"Wall-Heat No.421/04-

Lot17896/1-1-P.O.00000670

pcs.

lbs

22

1629

Lieferung

Delivered Material / Matériel délivré:

1. Chemische Analyse

Chemical Analysis / analyse chimique

Charge/
Cast Nomin.
max.

80117

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni
0,40	0,50	1,2	0,30	2,1	0,18	5,1	0,20					
0,07	0,15	2,0	0,04	2,9	0,28	6,1						
		1,53		2,48	0,19	0,87	0,04	<0,05				

Elements without indication < 0,01 %

2. Mechanische Eigenschaften

Mechanical Properties / Valeurs Mécaniques

An
Rein.
max.tensile
(Rm) ksiyield
(Rp0,2) ksielongation
2" %elongation
A %Hardness
HB

Heat No.

	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A %	Hardness HB	Heat No.
1	86,565	79,315	11,0	11,0	176	421/04 - 22 pcs.
2	87,145	80,185	10,0	10,0	173	
3	86,855	79,460	10,5	10,5	173	
4	86,855	79,895	12,0	12,0	178	

Ergebnis der Prüfungen:

Test results:

Resultats:

Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

We confirm that the delivery has been tested and applies to the agreements made on receipt of the order
Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

Form: rprocess

Customer PO	P.O.00000670
ALUnna ref. no.	17896/1
Date:	04.26.06

Dart Aerospace P.O.00000670 Box No.
D6009-129 Made in Germany
Dest.Hawkesbury Ont Canada

Free from live plant pests

I hereby declare that the wooden packing material are totally free from bark and apparently free from live plant pests										Boxdimension		
Item no.	Box no.	OD (inch)	ID (inch)	Wall (inch)	Net Weight (lbs)	Tare lbs	Gross Weight	Pieces	lengths (ft)	Lengths (inch)	Width (inch)	height (inch)
1	1	3,500		0,625	891	282	1173	12 ✓	11	177,165	17,717	22,441
1	2	3,500		0,625	739	251	990	10 ✓	11	177,165	15,748	22,441
						1629	533	2163	22			
						2,18 m³						